

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125385

Tuesday, October 07, 2014 10:42:39 AM

125385

Page 2

Item ID: D4635-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Ceiling Panel Assembly, RH
Start Date: 10/21/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/21/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									DAS
QC	Memo	0.00							9
Quality Control									9-89
130	Identify as per dwg & Stock Location: _____	0.00							
130									DAS
Packaging	Memo	0.00							06
Packaging									9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

1125 15-02-02

252-2

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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 125385

125385

Parent Item: D4635-044

D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Doc Release DL
13/07/09 DL verf:DD

IPP Rev B
IPP Rev C Dwg. Update
IPP Rev D Dwg Update 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-144		Manufactured	No			100	Each	1.0000	1	1		DAS 27 9-89	
D4635-144													
Aft Ceiling Replacement Panel Assembly, RH													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF		1							
				124277		1							
D4646-1		Manufactured	No			100	Each	99.0000	1	1		DAS 27 9-89	
D4646-1													
Plenum Cap Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF3		99							
				121007		1							
				124234		96							
				85289		2							
D4652-1		Manufactured	No			100	Each	0.0000	1	1		DAS 27 9-89	
D4652-1													
Air Valve, 1.16 Id Disk Type													

B12S208**

4/10/27

**

4/10/27

**

4/10/27

B11203

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 125385

125385

Parent Item: D4635-044

D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

D4655-1

Manufactured No

100

Each

124.0000

1

1

D4655-1

Speaker

DAS
27
9-29
4/10/27

Location

Loc Qty

Loc Code

MF

21

117634

21

MF3

63

111827

15

92333

6

93061

42

MF4

13

117634

13

MF5

2

112008

2

ST071

25

112009

25

D4708-9

Manufactured No

100

Each

51.0000

1

1

D4708-9

Lanyard

DAS
27
9-29
4/10/27

Location

Loc Qty

Loc Code

MF3

51

112122

51

D4728-046

Manufactured No

100

Each

11.0000

1

1

D4728-046

RH Cabin Speaker #3

DAS
27
9-29
4/10/27

Location

Loc Qty

Loc Code

MF

11

117928

11

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 125385

125385

Parent Item: D4635-044

D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

D4743-1 Manufactured No

100 Each 34.0000 1 1

D4743-1

Speaker Grill

**

DAS
27
9-99
4/10/14

Location

Loc Qty

Loc Code

MF

34

124115

34

MS21044-N08

Purchased No

100 Each 193.0000 4 4

MS21044-N08

Nut

**

DAS
27
9-99
4/10/14

Location

Loc Qty

Loc Code

ST306

193

123741

7

m127813

14

m128300

1

m128429

13

m128578

6

m128650

14

m129499

1

m129630

10

m130297

127

MS21919-WDG8

Purchased No

100 Each 206.0000 3 3

MS21919-WDG8

Clamp

**

DAS
27
9-99
4/10/14

Location

Loc Qty

Loc Code

MF4

206

123900

4

m128057

202

DQA: _____ Date: _____

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Work Order ID: 125385

125385

Parent Item: D4635-044

D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

MS24693-BB51

Purchased

No

100

Each

631.0000

4

4

MS24693-BB51

Screw

27
9-89
M/10/127

Location

Loc Qty

Loc Code

ST296

631

m128057

631

4
4

NAS1149DN832J

Purchased

No

100

Each

1,649.000

4

4

NAS1149DN832.J

Washer

PAS
27
9-89
M/10/127

Location

Loc Qty

Loc Code

ST277

1649

M128948

147

124555

145

M126319

11

M127255

36

M128429

883

M129499

135

M129541

292

4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

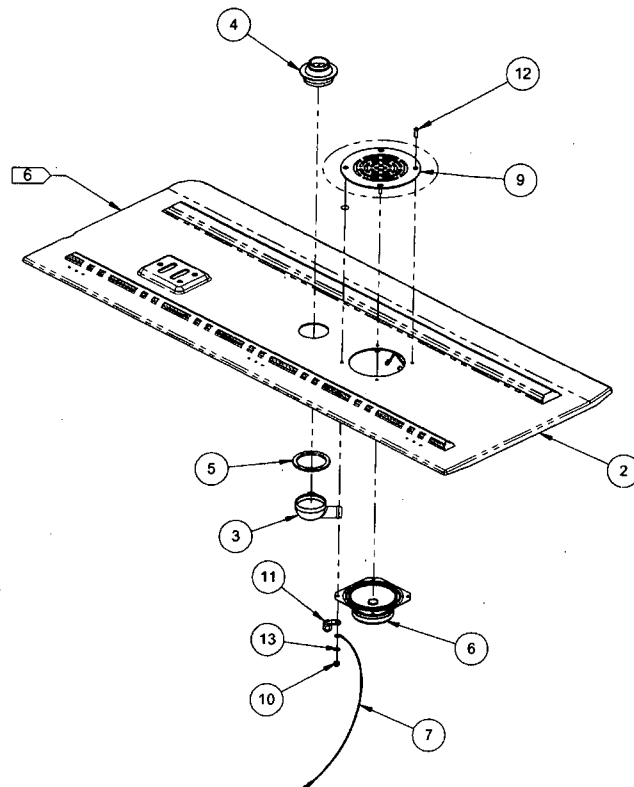
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM NO.	QTY. -044	PART NUMBER	DESCRIPTION
1	X	D4635-044	RH, AFT CEILING PANEL ASSY
2	1	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-1	AIR VALVE
5	1	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
6	1	D4655-1	SPEAKER
7	1	D4708-9	LANYARD
8	1	D4728-046	RH SPEAKER #3 HARNESS ASSEMBLY
9	1	D4743-1	SPEAKER GRILL
10	4	MS21044-N08	NUT
11	3	MS21919WDG8	CLAMP
12	4	MS24693-BB51	SCREW
13	4	NAS1149DN832J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125385 MJS

14-10-09

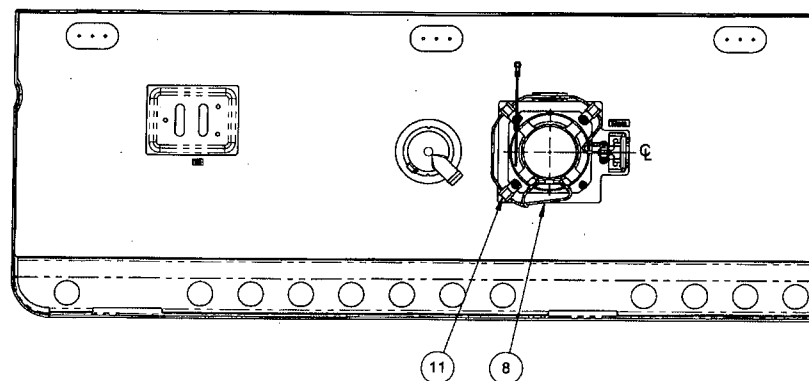
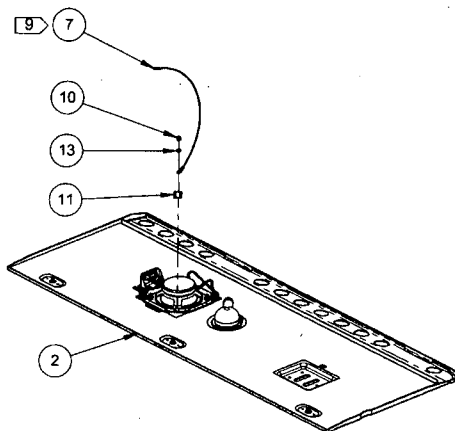
D4635-044 RH, AFT CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 5.0 lbs
- 8) INSTALL D4728-046 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

RELEASED
2014-01-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4635	SHEET 7 OF 18
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	OUTBOARD CEILING PANELS	NTS
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D4635-044 RH, AFT CEILING PANEL ASSY
AUXILIARY VIEW

RELEASE
2014-01-22
MD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4635	SHEET 8 OF 18
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